



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3205-00E

Job Sheet 191527



Part No: RBE350A93-3205-00E

Job Qty: 4 pcs

Part Name: Engine Gear Box Input Flange Holding Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/4/19

Job Tracking No:

Due Date: 4/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A93-3205-00E Rev 2A IPP Rev A 17.12.21 New issue DP Verify DD

Ship Via:

Bill of Materials

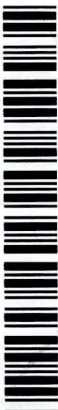
Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Waterjet - Omax - 1	4 pcs	4/18/19	4/18/19	0.00	0.40	Waterjet - Omax	pc 19/04/01
110	QC 2	4 pcs	4/18/19	4/18/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	pc 19/04/01
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 613 632-5200
FAX: 613 632-5246
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S168976



Part: RBE350A93-3205-00E

Job No: 191527

Serial No/Batch: S168976

Revision: 2A

Inspector:

Exp Date:

Instructions:

Date: 04/02/19

3/4/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				QC 2 - 64	
120 NV5000 - 1 - B4B	4 pcs	4/18/19	0.00 4.00	NV5000 - 1 - B4B	PJ 19-04-05
				NV5000 - 2 - B4B	
130 QC 2	4 pcs	4/18/19	0.00 0.00	QC 2 - 1	PJ 19-04-05
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
140 QC 8	4 pcs	4/18/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	BA 19-04-12
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
170 Outsource - 4 - Anodize	4 pcs	4/18/19		ATG001-VC	10 04/15/2019 PL
180 Packaging 2-1 - Receive - B4B	4 pcs	4/18/19	0.00 0.00	Packaging 2 - 1 - B4B	
	8 pcs			Packaging 2 - 2 - B4B	

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				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP APR 22 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
190 QC 6	4 pcs	4/18/19	0.00 0.00	QC 6 - 42	
				QC 6 - 9	DAS
				QC 6 - 68	APR 22 2019 68
				QC 6 - 61	9-89
191 Small Fab - 2 - B4B	4 pcs	4/18/19	0.00 0.80	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	DAS
				Small Fab - 3 - B4B	71
				Small Fab - 4 - B4B	9-89
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	19-4-24
192 QC 5	4 pcs	4/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				Plex 3/4/19 11:23 AM Dart.lajeunesse.mari	

206 Packaging 3-1 - Stock - B4B 4 pcs 4/18/19 0.00 0.00	QC 5 - 9		
	QC 5 - 50	338	6107 7
	QC 5 - 30		
	Packaging 3 - 1 - B4B		
	Packaging 3 - 2 - B4B		
	Packaging 3 - 3 - B4B		
	Packaging 3 - 4 - B4B		
	Packaging 3 - 5 - B4B		
	Packaging 3 - 6 - B4B		
	Packaging 3 - 7 - B4B		
	Packaging 3 - 8 - B4B	338	
	Packaging 3 - 9 - B4B		APR 24 2019
	Packaging 3 - 10 - B4B		
	Packaging 3 - 11 - B4B		
	Packaging 3 - 12 - B4B		
	Packaging 3 - 13 - B4B		
	Packaging 3 - 14 - B4B		
	Packaging 3 - 15 - B4B		
	Packaging 3 - 16 - B4B		
	Packaging 3 - 17 - B4B		
	Packaging 3 - 18 - B4B		
	Packaging 3 - 19 - B4B		
	Packaging 3 - 20 - B4B		
	Packaging 3 - 21 - B4B		
	Packaging 3 - 22 - B4B		
	Packaging 3 - 23 - B4B		
	Packaging 3 - 24 - B4B		
	Packaging 3 - 25 - B4B		
	Packaging 3 - 26 - B4B		
	Packaging 3 - 27 - B4B		
	Packaging 3 - 28 - B4B		
	Packaging 3 - 29 - B4B		
	Packaging 3 - 30 - B4B		
	Packaging 3 - 31 - B4B		
	Packaging 3 - 32 - B4B		
	Packaging 3 - 33 - B4B		
	Packaging 3 - 34 - B4B		
	Packaging 3 - 35 - B4B		
	Packaging 3 - 36 - B4B	DAG	
210 QC 21 - FG 4 pcs 4/18/19 0.00 0.00	QC 21 - FG - 21	21	
	QC 21 - FG - 70	9-89	
	QC 21 - SA - 53		APR 24 2019

Part Op 100 - OMAX (Waterjet 2) 1-Cut as per Dwg Dwg Rev: 2A Prog Rev: 2A 2-Deburr if necessary
Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
120 - NV5000-2 (MORI SEIKI VERTICAL MACHINE #2) 1-Machine as per folio FB743 FOLIO REV: AA DWG REV: 2A 2-Deburr 3-Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.
130 - (QC2- Inspect parts off machine FAI/FAIB)
140 - (QC8- Inspect parts - second check)
170 - Issue P/O to AD: PO 043202 -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A93-3205-00E Rev. 2A
180 - (Receive & Inspect for Damage & Mat'l Certs)
190 - (QC6- All purchased or subcontracted products)
191 - (Small Fab) Pick, bag and tag. ***See engineering for hardware sign off. WAS AN315-5, IS AN315-5R***
192 - (QC5- Inspect part completeness to step on W/O)
206 - (Identify as per dwg & Stock Location 6A143) Bag and tag
210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.250	6061T6 Sheet .250	1.6000 sf (.4 ea)	100-Waterjet - Omax - 1	5128987
AN315-5R	Nut 5/16-24	12 Ea (3 ea)	191-Small Fab - 2 - B4B	5166946 5128987
AN5-7	Hex Head Cap Screw	12 Ea (3 ea)	191-Small Fab - 2 - B4B	5174280 5128987
NAS1149F0563P	Washer	12 Ea (3 ea)	191-Small Fab - 2 - B4B	5128987 (4) 5165985 (9)

Job Allocations

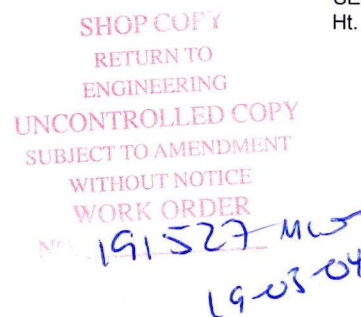
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	M6061T6S.250	2	65	0
191-Small Fab - 2 - B4B	AN315-5R	12	147	0
	AN5-7	12	151	0
	NAS1149F0563P	12	461	0

Part Specifications

Specifications could not be found.

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	PER HELI PRODUCTS TOOLS.	10/22/09	WP	DW
2	CH'D HOLE DIAMETER FROM .402 TO .410, ADDED MISSING R.063 DIM. PER G.E.	9/15/11	RJC	RW
2A	CORRECTED T/N WAS RBEA93-3205-00E IS RBE350A93-3205-00E. CH'D DIMENSION PRECISION FROM .XXX TO .XX ON NON-CRITICAL PARTS	11/5/13	RJC	RW



 RED BARN MACHINE	
TITLE ENGINE GEAR BOX INPUT FLANGE HOLDING WRENCH	
DWG NO. RBE350A93-3205-00E	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1	FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 X 45° PR. 015 R	
2. DIMENSIONAL LIMITS AFTER PLATING	
SCALE NTS	DATE 10-22-08
DRAWN BY: PERRITT	APPROVED <i>D Weil</i>
HEAT TREAT FINISH	ANODIZE RED
SPEC MIL-A-8625F, TYPE II, CLASS I	USED ON MODEL
EUROCOPTER AS350/355	
SCALE 1 of 1	SHEET 1 of 1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043202



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043202
PO Date: 4/15/19
Due Date: 4/22/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191527	RBE350A93-3205-00E	Engine Gear Box Input Flange Holding Wrench -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A93-3205-00E Rev. 2A	Firmed	-	4/22/19	8 pcs	0 pcs	8 pcs	\$15.00/pcs	\$120.00
2	191771	C45-11-1	Sideplate, Solenoid Side (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to Groupe Altech : -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	4/22/19	10 pcs	0 pcs	10 pcs	\$6.75/pcs	\$67.50



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PURCHASE ORDER

PO043202



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	191775	C45-2-1	Sideplate - MRK Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	4/22/19	11 pcs	0 pcs	11 pcs	\$6.75/pcs	\$74.25

X11 APR 22 2019 DP

Grand Total: \$261.75

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/16/19 9:25 AM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance

(018516-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

018516 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
18-Apr-2019		SPARTAKOS BOUNTOURIS		PO043202				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A93-3205-00E Rev.	RBE350A93-3205-00E ANODIZE RED PER IAW MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	8	8	0	0	68 9-89
2	C45-11-1 Rev.	C45-11-1 01-ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	10	10	0	0	0
3	C45-2-1 Rev.	C45-2-1 01-ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	11	11	0	0	0

Notes Additionnelles / Additional Notes

3 boîtes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.